



LORD TECHNICAL DATA

LORD® 850 and 852 Toughened Structural Acrylic Adhesives with LORD Accelerator 25GB

Description

LORD® 850 and 852 acrylic adhesives in combination with LORD Accelerator 25GB can be used to replace welding, brazing, riveting and other mechanical fastening methods. These toughened structural adhesives perform particularly well in low-temperature environments and applications that are subject to high impact, high peel loads or high fatigue. LORD 850 and 852 adhesives provide a range of working times to accommodate a wide variety of process requirements.

LORD 850 and 852 adhesives, when mixed with LORD Accelerator 25GB, create adhesive systems that bond a wide variety of prepared or unprepared metals and some engineered plastics. These adhesive systems are specifically formulated to provide the highest impact and peel strengths available in a room temperature curing adhesive with exceptional cohesive failure mode.

LORD Accelerator 25GB allows precise control of the adhesive bondline thickness due to its content of glass beads. For further detailed information, refer to the LORD Accelerator 25GB data sheet.

Features and Benefits

Versatile – bonds a wide range of unprepared metals with minimal substrate preparation, as well as polymer composite substrates such as FRP.

Durable – provides high strength for high-end structural bonding applications; 100% elongation improves impact strength and fatigue resistance.

Temperature Resistant – performs at temperatures from -40°F to +300°F (-40°C to +149°C); tolerates e-coat bake with cohesive failure at 338°F (170°C).

Environmentally Resistant – resists dilute acids, alkalis, solvents, greases, oils, moisture, salt spray and weathering; provides excellent resistance to indirect UV exposure.

Non-Sag - remains in position when applied on vertical or overhead surfaces, allowing for greater process flexibility.

Typical Properties*

	850	852
Appearance	Amber Paste	Amber Paste
Viscosity, cP @ 77°F (25°C) Brookfield	100,000-500,000	100,000-500,000
Density		
lb/gal	8.00-8.30	8.00-8.30
(kg/m ³)	(959-995)	(959-995)
Flash Point, °F (°C)	59 (15)	59 (15)

*Data is typical and not to be used for specification purposes.

Application

Surface Preparation – Remove grease, loose contamination or poorly adhering oxides from metal surfaces. Normal amounts of mill oils and drawing compounds usually do not present a problem in adhesion. Most plastics require a simple cleaning before bonding. Some may require abrading for optimum performance.

Mixing – Mix LORD 850 or 852 adhesive with the proper amount of LORD Accelerator 25GB. Handheld cartridges will automatically dispense the correct volumetric ratio of each component. Even color distribution visually indicates a thorough mix. Once mixed, the adhesive cures rapidly.

Applying – Apply adhesive using handheld cartridges or automatic meter/mix/dispense equipment.

- Handheld Cartridges
 1. Load the cartridge into the applicator gun and remove the end caps.
 2. Level the plungers by expelling a small amount of adhesive to ensure both sides are level.
 3. Attach mixing tip and expel a mixer's length of adhesive.
 4. Apply adhesive to substrate and mate the parts within the working time of the adhesive. Clamp in position until adhesive reaches handling strength. Do not re-expose adhesive to air once parts are mated. Mated parts should be repositioned by sliding to achieve proper alignment.
- Meter/Mix/Dispense Equipment
Contact your LORD representative if assistance is needed using this equipment.

Curing – Cure begins immediately once adhesive and accelerator are mixed. Time to handling strength is dependent on adhesive used. Complete cure requires 2-5 hours at room temperature. Mating surfaces must be held in contact during the entire curing process. Cure rate can be accelerated by applying modest heat [$<150^{\circ}\text{F}$ ($<66^{\circ}\text{C}$)].

Cleanup – Clean equipment and tools prior to the adhesive cure with solvents such as isopropyl alcohol, acetone or methyl ethyl ketone (MEK). Once adhesive is cured, heat the adhesive to 400°F (204°C) or above to soften the adhesive. This allows the parts to be separated and the adhesive to be more easily removed.

Shelf Life/Storage

Shelf life is six months when stored below 77°F (25°C) in original, unopened container. Storage temperatures of $40\text{-}50^{\circ}\text{F}$ ($4\text{-}10^{\circ}\text{C}$) are recommended. If stored cold, allow product to return to room temperature before using. Protect from exposure to direct sunlight.

LORD 850 and 852 adhesives are flammable. Do not store or use near heat, sparks or open flame.

Cautionary Information

Before using this or any LORD product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.



Typical Properties* of Adhesive Mixed with Recommended Accelerator

	850/25GB	852/25GB
Mix Ratio by Volume, Adhesive to Accelerator	10:1	10:1
Solids Content, %	100	100
Working Time, min @ 75°F (24°C)	6-10	20-25
Time to Handling Strength, min @ 75°F (24°C) 50 psi Shear	18-24	50-70
Full Cure Time, hr @ 75°F (24°C)	2**	5
Mixed Appearance	Red Paste	Red Paste

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**Reaches 90% of its full strength after 1 hour.

Typical Cured Properties* – LORD Adhesive/LORD Accelerator 25GB

	850	852
Hardness Shore D	66	67
Tensile Strength at Break, psi (MPa) ASTM D638, modified	2610 (18.0)	2683 (18.5)
Elongation, % ASTM D638, modified	100	100
Young's Modulus, psi (MPa) ASTM D638, modified	105,000 (724)	125,000 (862)
Glass Transition Temperature, °F (°C) ASTM E1640-99, by DMA	176 (80)	178 (81)

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Bond Performance* – LORD 850 Adhesive/LORD Accelerator 25GB

Substrates	Aluminum to Aluminum	EZG to EZG	CRS to CRS
Lap Shear @ Room Temperature, psi (MPa) Failure Mode	2617 (18.1) C	2081 (14.4) C	2885 (19.9) C
Lap Shear @ 180°F (82°C), psi (MPa) Failure Mode	1044 (7.2) C	1075 (7.4) C	1157 (8.0) C
Lap Shear @ -30°F (-34°C), psi (MPa) Failure Mode	3183 (22.0) TLC	2568 (17.7) TLC	4017 (27.7) TLC
Lap Shear after 14 days @ 95°F (38°C), 95% RH, psi (MPa) Failure Mode	2584 (17.8) C	2046 (14.1) C	2790 (19.2) C
Lap Shear after 500 hours Salt Spray Exposure, psi (MPa) ASTM B117 Failure Mode	2157 (14.9) C/A	1482 (10.2) C/A	1908 (13.2) C/A
T-Peel @ Room Temperature, pli (N/cm) Failure Mode	26 (46) C	45 (79) C	45 (79) C

Substrate

Aluminum, 0.032" thick 6061T6
Electrogalvanized Steel (EZG), 0.032" thick
Cold Rolled Steel (CRS), 0.032" thick

Surface Treatment

IPA Wipe
IPA Wipe
IPA Wipe

Bonded Parameters

Metal Lap Shears (ASTM D1002)
T-Peel (ASTM D1876 modified)

Bond Area

1.0"x0.5"
1.0"x3.0"

Film Thickness

0.010"
0.010"

Cure

24 hr @ RT
24 hr @ RT

Mix Ratio

10:1 by Volume
10:1 by Volume

Failure Mode Definition

Adhesive Failure
Cohesive Failure
Thin Layer Cohesive Failure

Abbreviation

A
C
TLC

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Bond Performance* – LORD 852 Adhesive/LORD Accelerator 25GB

Substrates	Aluminum to Aluminum	EZG to EZG	CRS to CRS	
Lap Shear @ Room Temperature, psi (MPa) Failure Mode	2880 (19.9) C	2115 (14.6) C	2975 (20.5) C	
Lap Shear @ 180°F (82°C), psi (MPa) Failure Mode	1089 (7.5) C	1090 (7.5) C	1320 (9.1) C	
Lap Shear @ -30°F (-34°C), psi (MPa) Failure Mode	3380 (23.3) TLC	2627 (18.1) TLC	4236 (29.2) TLC	
Lap Shear after 14 days @ 95°F (38°C), 95% RH, psi (MPa) Failure Mode	2752 (19.0) C	2016 (13.9) C	2826 (19.5) C	
Lap Shear after 500 hours Salt Spray Exposure, psi (MPa) ASTM B117 Failure Mode	2022 (13.9) C/A	1780 (12.3) C/A	1807 (12.5) C/A	
T-Peel @ Room Temperature, pli (N/cm) Failure Mode	26 (46) C	47 (82) C	49 (86) C	
Substrate	Surface Treatment			
Aluminum, 0.032" thick 6061T6	IPA Wipe			
Electrogalvanized Steel (EZG), 0.032" thick	IPA Wipe			
Cold Rolled Steel (CRS), 0.032" thick	IPA Wipe			
Bonded Parameters	Bond Area	Film Thickness	Cure	Mix Ratio
Metal Lap Shears (ASTM D1002)	1.0"x0.5"	0.010"	24 hr @ RT	10:1 by Volume
T-Peel (ASTM D1876 modified)	1.0"x3.0"	0.010"	24 hr @ RT	10:1 by Volume
Failure Mode Definition	Abbreviation			
Adhesive Failure	A			
Cohesive Failure	C			
Thin Layer Cohesive Failure	TLC			

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Values stated in this technical data sheet represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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